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C45-19C

Job Sheet 185261



9524
Nov 8

Part No: C45-19C

Job Qty: 1 ea

Part Name: Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/24/18

Job Tracking No:

Due Date: 11/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: C45-19C REV.5 IPP REV:A 18.01.22 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/16/18	0.00	0.00	Start Up Large Fab-7		CL
100	Large Fab	1 pcs		11/16/18	0.00	10.00	Large Fab 8		CL
110	QC	1 pcs		11/16/18	0.00	0.00	QC9		
120	QC	1 pcs		11/16/18	0.00	0.00	QC5		
130	Powdercoat	1 pcs		11/16/18	0.00	0.50	Powdercoat6		BL 18-11-14
140	QC	1 pcs		11/16/18	0.00	0.00	QC3		
150	Packaging	1 pcs		11/16/18	0.00	0.00	Packaging3-2		
160	QC21-SA	1 Ea		11/16/18	0.00	0.00	QC21		

Part Op 100 - 1-MANUFACTURE AS PER DWG, TACK WELD FOR INSPECTION BY: _____ USE WELDING JIG C45.

Descriptions: 2-Weld as per DWG. ***SEE NOTE 1, ALL HOLES MUST ALIGN***

130 - START TIME: 11:25 OVEN TEMPERATURE: 520° FINISH TIME: 12:25

M129223°

Job BOM

006457

Part / Item	Component Name	Quantity	Operation	Container
C45-18-1	Lifting Plate	2 Ea (2 ea)	90-Start up Operation	71516
C45-18-5	Boss	2 Ea (2 ea)	90-Start up Operation	506485
C45-18-6	Bumper Bracket	1 Ea (1 ea)	90-Start up Operation	40681
MT-A513-T-1.000W0.120 A513 Seamless Alloy Steel Round Tubing 1"dia. x 0.120" Wall		10.5000 ft (10.5 ea)	90-Start up Operation	70826

Job Allocations



Container No: S127562



Part: C45-19C

Job No: 185261

Serial No/Batch: S127562

Revision: 5
Inspector:
Exp Date:
Instructions:

Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Required	Inventory	Allocated
2	16	0
2	8	0
1	6	0
11	200	0

found.

Plex 10/24/18 11:38 AM Dart.lajeunesse.marie

Date: 11/14/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

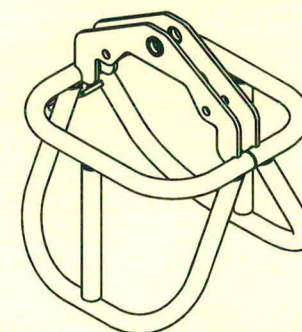
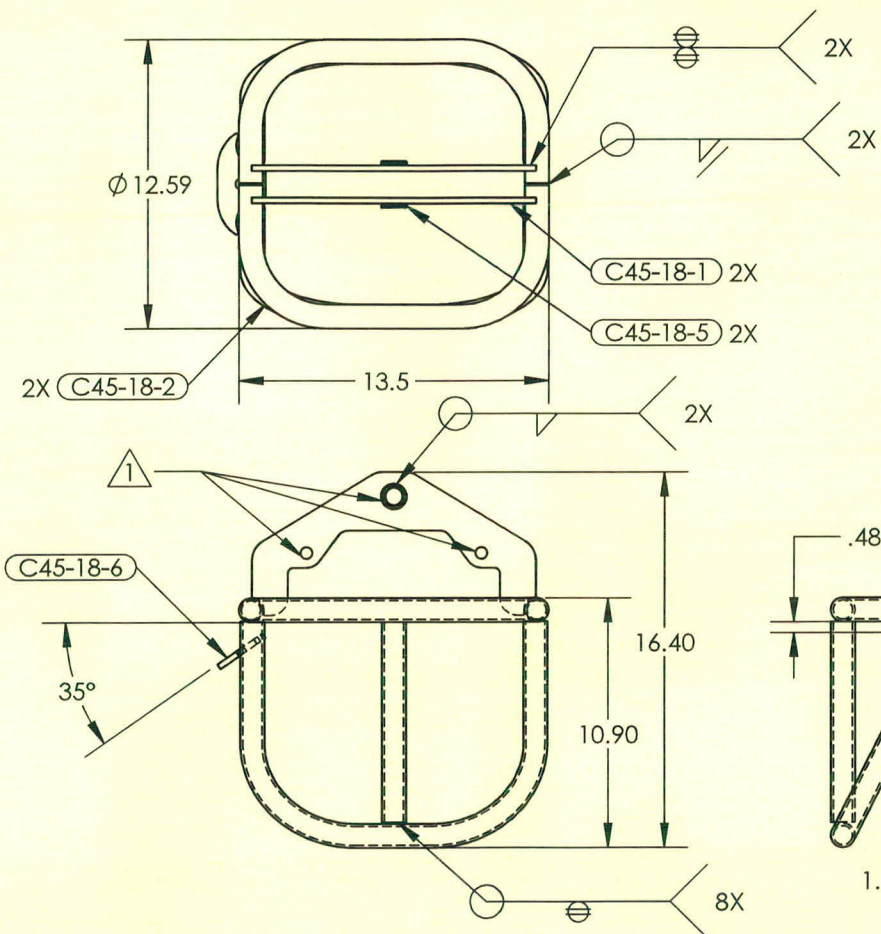
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
3		AS DRAWN BY CANAM.	11/16/2012	JAG
4	15-0087	UPDATED TO NEW DRAFTING STANDARDS. CH'D WIDTH BETWEEN LIFING PLATES WAS 1.14 IS 1.16 +.02 -.00. CH'D DIM WAS 1.29 IS .48. DELETED DIM .250. ADDED FIXTURE NOTE.	4/16/2015	RJC
5	16-0207	DELETED POWDER COAT RED FINISH SPEC, DELETED MATERIAL COLUMN FROM BOM. CH'D DWG TO SHEET METAL TOLERANCE.	11/2/2016	RJC



NOTES:

- THREE HOLES MUST BE ALIGNED FROM FRONT PLATE TO THE BACK PLATE.
- ASSEMBLE USING FIXTURE C45/C60-F.

DART AEROSPACE	
TITLE WELDMENT C45 CAGE	
DWG NO. C45-19C	REV 5
MAT'L HEAT TREAT FINISH POWDER COAT RED SPEC DRAWN BY: APICAL INDUSTRIES CHECKED: DUERFELDT OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125 ✓ 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL	
SCALE 1:8	DATE 7/21/2009
SHEET 1 OF 1	

B/O	Part #	UNIT QTY	Description
	C45-18-1	2	LIFTING PLATE
	C45-18-2	2	TOP SEMI-RING
	C45-18-3	2	SIDE LOOP
	C45-18-4	2	STIFFENER BAR
	C45-18-6	1	BUMPER BRACKET
	C45-18-5	2	BOSS

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WITHOUT NOTICE
WORK ORDER

NO. 185261 MLC
181024

